

AUFHAUSER Ni-60 is a high-chromium, boron-free oxidation-resistant nickel brazing filler alloy with enhanced flow characteristics.

Applications / Industries

Used for brazing stainless steel, carbon steel, nickel and nickel alloys, cobalt and cobalt alloys, copper in vacuum furnace. Used in the Automotive, Heavy Equipment, Food and Beverage, Marine, Aerospace and Military industries.

Nominal Composition, wt.%

Cr	Si	P	Ni
27.5 - 31.5	3.8 - 4.2	5.6 - 6.4	balance

Controlled Impurities, wt.%, max:

Al	Co	S	Se	Ti	Zr	Others (total)
0.05	0.10	0.02	0.005	0.05	0.05	0.50

Physical Properties

Solidus	1742°F (950°C)
Liquidus	1885°F (1030°C)
Recommended brazing range	1922 - 2050°F (1050 - 1121°C)
Density, theoretical	7.72 g/cm ³
Density, apparent -140 mesh powder	4.29 g/cm ³
Density, apparent -325 mesh powder	4.0 g/cm ³
Density, apparent -40 mesh paste	3.5 g/cm ³
Color	Grey
Viscosity, -140 paste at 20°C	800 - 900 Pa.s

Corrosion Resistance

Aufhauser Ni-60 is resistant to sulfuric, nitric, and hydrochloric acids.

Available Forms

Powder, paste

Paste Components

Binder (water based) 10-15%, metal powder balance.

Paste Storage Conditions

Under exclusion of moisture and chemicals in tightly closed containers at ambient temperature. Shelf life of paste is 6 months. Stir well before use.